# Work Order ID 62618

October 5, 2010 11:45:28 AM



Page

| Item | ID: | I | 0206 |
|------|-----|---|------|

Required Date: 10/22/10

6-642-441

Accept



Setup Start



**Revision ID:** 

Item Name: Replacement Skidtube

**Start Date:** 

10/05/10

QC:

Start Qty: 1.00

Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Sequence ID/

Date: 20-10-05 Tooling:

Start

Stop

Stop

Date:

SPC (Y/N):

Date:

Reject Accept

Run

Reject

Insp

Work Center ID **Draw Nbr** 

Operation Description

Set Up/ **Run Hours**  **Tool ID** 

Tool # Plan Code

Qty Qty Number

Stamp

D2650

Rev F

**Revision Nbr** 

100

DOCUMENT CONTROL

Memo

0.00

0.00

Document Control .

Photocopy bluefile and create labels per PPP D206-642-441

CHG002

| Dart Ae | rospace | Ltd               | <del></del>          |                             |            |              |              |        |                               |                          |
|---------|---------|-------------------|----------------------|-----------------------------|------------|--------------|--------------|--------|-------------------------------|--------------------------|
| W/O:    |         |                   | WO                   | RK ORDER CH                 | ANGES      |              |              | •      |                               | <u>-</u>                 |
| DATE    | STEP    | PROCEDURE CHANGE  |                      |                             |            | Ву           | Date         | Qty    | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
| 1       |         |                   |                      |                             |            |              |              |        | ;                             | چې د                     |
|         |         |                   |                      |                             |            |              |              |        | - 1-2-2 M                     |                          |
| Part No | :       | PAR #:            | Fault Categ          | jory:                       | NC         | R: Yes       | No <b>DQ</b> | A:     | Date:                         |                          |
|         | R       | esolution:        | Disposition          | n:                          | Q <i>A</i> | A: N/C C     | losed:       |        | Date: _                       |                          |
| NCR:    |         | V                 | WORK ORDE            | R NON-CONFO                 | RMANC      | E (NCI       | R)           |        |                               |                          |
|         |         | Description of NC |                      | Corrective Action           | Section B  |              | Verific      | cation | Approval                      | Approval                 |
| DATE    | STEP    | Section A         | Initial<br>Chief Eng | Action Descrip<br>Chief Eng | otion      | Sign<br>Date | & Secti      | ion C  | Chief Eng                     | QC Inspector             |
|         |         |                   |                      |                             |            |              |              |        |                               |                          |
|         |         |                   |                      |                             |            |              |              |        |                               |                          |

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|------|------|-------------------|----------------------|------------------------------|-------------|--------------|-----------------------|--------------------------|
|      |      | Description of NC |                      | Corrective Action Section B  |             | Verification | Ammunual              | Annuaral                 |
| DATE | STEP | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign & Date | Section C    | Approval<br>Chief Eng | Approval<br>QC Inspector |
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Page 2

October 5, 2010 11:45:28 AM

Item ID:

D206-642-441

**Revision ID:** 

**Item Name:** 

Replacement Skidtube

**Start Date:** 

10/05/10

QC:

Start Qty: 1.00

Required Date: 10/22/10

Req'd Qty: 1.00



Accept



Setup Start



Stop

Reference:

Approvals:

Process Plan: Date:

Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Date:

Tool ID

Date:

Tool#

**Cust Item ID:** 

**Customer:** 

Plan

Code

Stop



Reject

Qty

Sequence ID/ **Work Center ID** 

110

Skidtubes

Skidtubes

Operation Description Set Up/ **Run Hours** 

0.00

0.00

Skidtubes

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as

A/R Aluminum Rod M11250

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

Run

Accept

Qty

Start



Insp.

Stamp

10-10-6

Reject

Number

|              | •        |                   |                      |  |                 |           |         |                               | •                        |
|--------------|----------|-------------------|----------------------|--|-----------------|-----------|---------|-------------------------------|--------------------------|
| W/O:         |          |                   | W                    | ORK ORDER CHANG  | ES              |           |         |                               |                          |
| DATE         | STEP     | PRO               | CEDURE CHA           | ANGE   | Ву              | Date      | Qty     | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|              |          |                   |                      |  |                 | }         | ;       |                               | ·                        |
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| Part No      | •        | PAR #:            | Fault Cate           | egory:   | _ NCR: Yes      | s No De   | QA:     | _ Date: _                     |                          |
|              | R        | esolution:        | Disposition          | on:  | _ QA: N/C       | Closed: _ |         | Date: _                       |                          |
| NCR:         | i        | V                 | VORK ORD             | ER NON-CONFORMA  | ANCE (NC        | R)        |         |                               |                          |
| DATE         | STEP     | Description of NC |                      |  | etion B Verific |           |         | Approval                      | Approval                 |
| DAIL         | SIEP     | Section A         | Initial<br>Chief Eng | Action Description Chief Eng   | Sigr<br>Da      |           | ction C | Chief Eng                     | QC Inspector             |
|              | <u>'</u> |                   |                      |  |                 |           |         |                               |                          |
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### Work Order ID 62618

October 5, 2010 11:45:33 AM



Page 3

Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: Replacement Skidtube

**Start Date:** 

10/05/10

Start Qty: 1.00

Required Date: 10/22/10

Req'd Qty: 1.00



Date:

**Cust Item ID: Customer:** 

Tool ID

Reference:

**Approvals:** 

Process Plan: Date:

Tooling:

SPC (Y/N):

Date: Date:

Run

Start

Stop



Sequence ID/

**Work Center ID** 

115

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

Memo

Set Up/ **Run Hours** 

Tool # Plan

Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

116

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

2 volvoloz

120

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

|         |        |                   |  |                              |              |              |            |                                     | ¥                        |
|---------|--------|-------------------|--|------------------------------|--------------|--------------|------------|-------------------------------------|--------------------------|
| W/O:    |        |                   | WO                                     | RK ORDER CHANG               | ES           |              |            |                                     |                          |
| DATE    | STEP P |                   | OCEDURE CHAN                           | IGE                          | Ву           | Date         | Qty        | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|         |        |                   |  |                              |              |              |            |                                     |                          |
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| Part No | •      | PAR #:            | Fault Categ                            | jory:                        | _ NCR: Yes   | No <b>DQ</b> | <b>A</b> : | Date: _                             |                          |
|         | Res    | olution:          | Disposition                            | :                            | _ QA: N/C C  | losed:       |            | Date: _                             |                          |
| NCR:    |        | ,                 | WORK ORDE                              | R NON-CONFORMA               | ANCE (NCI    | 7)           |            |                                     |                          |
| DATE    | STEP   | Description of NC | NC Corrective Action Se                |                              |              | Verifi       | cation     | Approval                            | Approval                 |
| DATE    | SIEP   | Section A         | Initial<br>Chief Eng                   | Action Description Chief Eng | Sign<br>Date | &   Sect     | ion C      | Chief Eng                           | QC Inspector             |
|         |        |                   |  |                              | [<br>]<br>   |              |            |                                     |                          |
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#### Work Order ID 62618

October 5, 2010 11:45:39 AM



Page 4

Item ID:

D206-642-441

Accept



Setup Start

Stop

Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

10/05/10

Start Qty: 1.00

Required Date: 10/22/10

Req'd Qty: 1.00

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Operation

Description

Date:

Date: Tooling:

**SPC (Y/N):** 

Set Up/

Run Hours

Tool # Plan

Qty

Reject Qty

Insp. Stamp

Work Center ID

130

Sequence ID/

Memo

QC3- Inspect Part Finish

0.00

**Tool ID** 

Date:

Date:

Code

Accept

Reject Number

Quality Control

0.00 -

Run

| _       |      |                   |  |                              |              |              |        |                               | 1                        |
|---------|------|-------------------|--|------------------------------|--------------|--------------|--------|-------------------------------|--------------------------|
| W/O:    |      |                   | WO   | RK ORDER CHANG               | ES           | <del> </del> |        |                               |                          |
| DATE    | STEP | PRO               | OCEDURE CHAN                                 | IGE                          | By Date      |              |        | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|         |      |                   |  |                              |              |              |        |                               |                          |
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|         |      |                   |  |                              |              |              |        |                               |                          |
| Part No | •    | PAR #:            | Fault Categ                                  | ory:                         | _ NCR: Yes   | No <b>DQ</b> | A:     | Date:                         |                          |
|         | Res  | solution:         | Disposition                                  | :                            | _ QA: N/C C  | losed:       |        | Date: _                       |                          |
| NCR:    |      | ,                 | WORK ORDE                                    | R NON-CONFORMA               | ANCE (NCI    | 7)           |        |                               | :                        |
| DATE    | STEP | Description of NC | escription of NC Corrective Action Section B |                              |              | Verifi       | cation | Approval                      | Approval                 |
|         | J.L. | Section A         | Initial<br>Chief Eng                         | Action Description Chief Eng | Sign<br>Date |              | ion C  | Chief Eng                     | QC Inspector             |
|         |      |                   |  |                              |              |              |        |                               |                          |
|         |      |                   |  |                              |              |              |        |                               |                          |
|         |      |                   |  |                              |              |              |        |                               |                          |
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|         |      |                   |  |                              |              |              |        |                               |                          |

Page 5

October 5, 2010 11:45:39 AM Item ID: D206-642-441 Accept Setup Start **Revision ID:** Stop **Item Name:** Replacement Skidtube **Start Date:** 10/05/10 Start Qty: 1.00 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 10/22/10 **Customer:** Reference: Start Run **Tooling:** Approvals: Process Plan: Date: Date: Stop Date: \_\_\_\_\_ QC: **SPC (Y/N):** Date: Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Accept Reject Reject Insp. Work Center ID Description Qty **Run Hours** Code Qty Number Stamp 140 0.00 Skidtubes Skidtubes 0.00 Skidtubes 1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. 4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting Start Date: 345 pr 1 Time: 10 - 10 - 1 Finish Date: 10/10/12 []
Time: [] 9.5000

A/R | Sikaflex-291 | M//5/1410 Sikaflex expiry date: 1/-/-30

|         |             |               |                    |                 | × *  |              |
|---------|-------------|---------------|--------------------|-----------------|--|--------------|
| W/O:    |             |               | WORK ORDER         | CHANGES         | A CONTRACTOR OF THE PARTY OF TH | 9            |
| DATE    | STEP        | PR            | OCEDURE CHANGE     | By Date         | Qty Approval Chief Eng / Prod Mgr  | Appiovai     |
|         |             | <b>&gt;</b> . |                    |                 | - 4  | QC Inspector |
|         |             |               |                    |                 |  |              |
|         |             | •             | <i>3</i> .         |                 |  |              |
| Part No | ·:          | PAR #:        | Fault Category:    | NCR: Yes No DQ  | A: Date: _   |              |
|         | Resolution: |               | Disposition:       | QA: N/C Closed: | Date: 🗻  | Mary Mary 19 |
| NAD     |             |               | WORK ORDER NON-COM | IEODMANCE (NCD) |  |              |

| NCR:       |             | W                 | ORK ORD              | ER NON-CONFORMANC            | E (NCR)          |              |                       |                         |
|------------|-------------|-------------------|----------------------|------------------------------|------------------|--------------|-----------------------|-------------------------|
|            |             | Description of NC |                      | Corrective Action Section B  |                  | Verification | Annessal              | A                       |
| DATE       | STEP        | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date   | Section C    | Approval<br>Chief Eng | Approval<br>QC Inspecto |
|            |             |                   |                      | ,                            |                  | ·            |                       | \$ 15<br>\$             |
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|            |             |                   |                      |                              | <b>1 8</b> , 6   |              | \$                    | ·                       |

Work Order ID October 5, 2010 711.45.39 AM D206-642-441 Item ID: **Revision ID:** Item Name: Replacement Skidtube **Start Date:** 10/05/10 Start Qty: 1.00 **Required Date:** 10/22/10 ‡ Req'd Qty: 1.00 Reference: Process Plan: **Approvals:** QC: GE CIC Sequence ID/ Operation **Work Center ID** 150 Quality Control

Accept



Setup Start



Stop

**Cust Item ID:** 

**Customer:** 

Date:

Tooling:

Date:

Start



Date:\_\_\_\_\_

SPC (Y/N):

Set Up/

Date:

Stop

Description

QC5- Inspect part completeness to step on W/O

**Run Hours** 0.00

Tool ID

Tool # Plan Accept Qty Code

Reject Qty

Run

Reject Number

Insp. Stamp

Memo

0.00

Skidtubes

Skidtubes

Memo

0.00

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16 3 Jon deen as per Dwg D2650 Deburr

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|--|
| DATE | STEP | PROCEDURE CHANGE   | Ву | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |  |
|      |      |                    |    |      |     |                                     |                          |  |  |
|      |      |                    |    |      |     |                                     |                          |  |  |
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|      |      |                    |    |      |     |                                     |                          |  |  |

Part No: <u>Nan6-642-44</u> PAR #: \_\_\_\_ Fault Category: <u>Skick blass</u> NCR: Yes No DQA: \_\_\_\_ Date: <u>b 16-20</u>

Resolution: \_\_\_\_ rework \_\_\_\_ Disposition: \_\_\_\_ rework \_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: <u>b 16-20</u>

| NCR: &   | 2618  | WC   | ORK OR               | DER NON-CONFORMANCE          | (NCR)          |              |           |              |
|----------|-------|--|----------------------|------------------------------|----------------|--------------|-----------|--------------|
| DATE     | STEP  | Description of NC  | 1 - 214 - 1          | Corrective Action Section B  | Cian 0         | Verification | Approval  | Approval     |
| DAIL     |       | Section A  | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Section C    | Chief Eng | QC Inspector |
| 10.10-30 | 160-3 | Pilot broke inside of the 13th x-bolt (Towards the AKT) own four yello location, going through the x-bolt. When the bit was changed, be more x-bolt spacers were bored too deep. This was coved by the bit | Pasion               | T P 13: 10 wage law ones     | 70             | 101020       | Posium    | 10 10 20     |
|          |       | being 0.080" longer than normal is shapper reduced to be adjusted. R. c. Touling New brand of bits   | Josima               | 22001                        | BE<br>10-10-20 |              |           |              |
|          |       |  |                      |                              |                |              | • :       |              |

### Work Order ID 62618

October 5, 2010 11:45:45 AM 🗟



Page 7

Item ID:

D206-642-441

Accept

Setup Start



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

10/05/10

QC:

Start Qty: 1.00

Required Date: 10/22/10

Req'd Qty: 1.00



**Cust Item ID: Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Date: Date:\_\_\_

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Run

Start

Stop



Stop

Sequence ID/ **Work Center ID** 

170

Skidtubes Skidtubes

Operation Description Set Up/ **Run Hours** 

HandFinishing

Memo

0.00

Install D2680-041 Nut Plate as per Dwg D2650

180

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

190

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Qty

Accept

Reject Qty

Reject Number

Insp. Stamp

| Dart A | Aeros | pace | Ltd |
|--------|-------|------|-----|
|--------|-------|------|-----|

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| W/O:        |      |                   | WO                | RK ORDER CHANG   | ES        |                     |         |                                     | ***                      |
| DATE        | STEP | PRO               | OCEDURE CHAI      | NGE  | Ву        | Date                | Qty     | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|             |      |                   |                   |  |           |                     |         |                                     |                          |
|             |      |                   |                   |  |           |                     |         |                                     |                          |
| <del></del> |      |                   |                   | ALCOHOL MARKET M |           |                     | -       |                                     |                          |
|             |      |                   |                   |  |           |                     |         | i.                                  | 1.5                      |
|             |      |                   |                   |  |           |                     |         |                                     |                          |
| Part No     | :    | PAR #:            | Fault Categ       | gory:  | _ NCR: Ye | s No <b>D</b> C     | A:      | Date: _                             |                          |
|             | Re   | esolution:        | Disposition       | );   | _ QA: N/C | Closed: _           |         | Date: _                             |                          |
| NCR:        |      |                   | WORK ORDE         | R NON-CONFORMA   | ANCE (NO  | CR)                 |         |                                     |                          |
| DATE        | STEP | Description of NC |                   |  | ion B     | Verif               | ication | Approval                            | Approval                 |
| DAIL        | SILF | Section A         | Initial Chief Eng | Action Description Chief Eng   | Sig<br>Da | າ& ∣ <sub>Sec</sub> | tion C  | Chief Eng                           | QC Inspector             |
|             |      | i<br>İ            |                   |  |           |                     |         |                                     |                          |
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|             |      |                   |                   |  |           |                     |         |                                     |                          |

NOTE: Date & initial all entries

700

#### Work Order ID 62618

October 5, 2010 11:45:45 AM



Page 8

Item ID:

D206-642-441

Accept



Setup Start



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 10/05/10 Required Date: 10/22/10

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Start

Stop



Reject

Number

Date:\_\_\_\_\_

SPC (Y/N):

Date:

Accept

Qty

Run

Stop



Insp.

Stamp

Sequence ID/ Work Center ID

200

HandFinish

Hand Finishing

Operation Description

Pressure Wash per QSI005 4.3

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan

Code

=> M 10/10/21 1 P

Reject

Qty

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in

211

SprayPaint

**Spray Painting** 

PRIME B (14 424 PAINT DELFLEET BLUE B 115 609
CLEAR DELFLEET B 113 3 CY 0.00 0.00

ZT 10-10-27 C

221

Quality Control

OC14- Inspect Spray Paint

Memo

0.00

Memo

| W/O:    | •    |                   | W                    | ORK ORDER CHANG               | ES           |              |             |                               |                          |
|---------|------|-------------------|----------------------|-------------------------------|--------------|--------------|-------------|-------------------------------|--------------------------|
| DATE    | STEP | PRO               | CEDURE CHA           |                               | Ву           | Date         | Qty         | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|         |      |                   |                      |                               |              |              |             |                               |                          |
|         | 1    |                   |                      |                               |              |              |             |                               |                          |
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| Part No | :    | PAR #:            | Fault Cate           | gory:                         | NCR: Yes     | No <b>DQ</b> | A:          | Date: _                       |                          |
|         | R    | esolution;        | Dispositio           | n:                            | _ QA: N/C C  | losed:       |             | Date: _                       |                          |
| NCR:    | 1.00 | V                 | VORK ORD             | ER NON-CONFORMA               | NCE (NC      | R)           |             |                               |                          |
| DATE    | STEP | Description of NC |                      | Corrective Action Section     |              | Verific      | cation      | Approval                      | Approval                 |
| DAIL    | SILF | Section A         | Initial<br>Chief Eng | Action Description  Chief Eng | Sign<br>Date | & Sect       | ion C       | Chief Eng                     | QC Inspector             |
|         |      |                   |                      |                               |              |              |             |                               |                          |
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#### Work Order ID 62618

October 5, 2010 11:45:50 AM



Page 9

Item ID:

D206-642-441

Accept



Setup Start



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

10/05/10

Start Oty: 1.00

Reg'd Oty: 1.00



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

| Approvals:    | P |
|---------------|---|
| zxppi o rais. |   |

Required Date: 10/22/10

QC:

Process Plan:

Date:

Date: **Tooling:** 

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Run Start



Stop

Reject

Qty

Stop

Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

230



HandFinish

Hand Finishing

Operation **Description** 

HandFinishing

Set Up/ **Run Hours** 

0.00

0.00

Accept

Qty

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R□□Sikaflex-291□ M [1469]□ Sikaflex expiry date: ☐ 10110

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

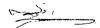
( 3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per OSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291 A/ 1409D Sikaflex expiry date: ☐ 10 16

6 Wing Walk as per Dwg D2650-7 and QSI 005 4.4



| W/O:    | -    |                   | W                    | ORK ORDER CHANG               | ES        |             |             |           |   | · · · · · · · · · · · · · · · · · · · |
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| DATE    | STEP | PRO               | OCEDURE CHA          | NGE                           | Ву        |             | Date        | Qty       | Approval Chief Eng / Prod Mgr                 | Approval<br>QC Inspector              |
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| Part No | •    | PAR #:            | Fault Cate           | gory:                         | _ NCR: Y  | es N        | o <b>DQ</b> | <b>A:</b> | Date:   |                                       |
|         | R    | esolution:        | Dispositio           | n:                            | _ QA: N/C | Clos        | sed:        |           | Date: _                                       |                                       |
| NCR:    |      |                   | WORK ORD             | ER NON-CONFORM                | ANCE (N   | CR)         |             |           | <u>, , , , , , , , , , , , , , , , , , , </u> |                                       |
| DATE    | STEP | Description of NC |                      |                               | ion B     |             | Verific     | ation     | Approval                                      | Approval                              |
| DATE    | SIEP | Section A         | Initial<br>Chief Eng | Action Description  Chief Eng |           | jn &<br>ate | Secti       | on C      | Chief Eng                                     | QC Inspector                          |
|         |      |                   |                      |                               |           |             |             |           |   |                                       |
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#### Work Order ID 62618

October 5, 2010 11:45:50 AM

Required Date: 10/22/10



Page 10

Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

10/05/10

Start Qty: 1.00

Req'd Qty: 1.00

Date:

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

QC: \_

Process Plan: \_\_\_\_\_

Date:

Tooling:

SPC (Y/N):

Date: Date: Run Start

Stop



Sequence ID/

**Work Center ID** 

240

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** 

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

250



Packaging

Packaging

Memo

Memo

0.00

0.00

Identify and pack for shipping as per PPP D206-642-441 Packaging

Location: PPP Rev:

260

QC21- Final Inspection - Work Order Release

0.00

Memo

Quality Control

| W/O:        |      |                   | W                    | ORK ORDER CHANG              | iES            |              |            |                               |                          |
|-------------|------|-------------------|----------------------|------------------------------|----------------|--------------|------------|-------------------------------|--------------------------|
| DATE        | STEP | PRO               | CEDURE CH            | ANGE                         | Ву             | Date         | Qty        | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
| -           |      |                   |                      | ,                            |                |              |            | Frod Wgi                      |                          |
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| - Variation |      | 70                |                      |                              |                |              |            |                               |                          |
| Part No     | :    | PAR #:            | Fault Cat            | egory:                       | _ NCR: Yes     | No <b>DQ</b> | <b>\</b> : | _ Date: _                     |                          |
|             | R    | esolution:        | Dispositi            | on:                          | QA: N/C CI     | osed:        |            | Date: _                       |                          |
| NCR:        |      | V                 | VORK ORE             | DER NON-CONFORM              | ANCE (NCF      | R)           |            |                               |                          |
| DATE        | STEP | Description of NC |                      |                              | tion B         | Verific      | ation      | Approval                      | Approvai                 |
| DATE        | SIEP | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign 8<br>Date | Section      |            | Chief Eng                     | QC Inspector             |
|             |      |                   |                      |                              | i              |              |            |                               |                          |
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# **Picklist Print**

October 5, 2010 11:45:16 AM

Work Order ID: 62618

Parent Item:

D206-642-441

Comments:

Parent Item Name: Replacement Skidtube



Start Date: 10/05/10

Start Qty: 1.00

Required Date: 10/22/10

Page 1

Required Qty: 1.00

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM

IPP Rev:I 08-05-01 add QC3 DD verified by:EC
IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC

IPP rev K

| r Kev.j | 00-09-29   | ievr as pei uw | vg DD vermed by, EC |  |
|---------|------------|----------------|---------------------|--|
| .09.27  | SS washers | for wearplates | EC verified by: DD  |  |

| ]                               | 10.09.27 SS wash       | ers for wearplat | es EC v         | erified by: D       | D                |                 |                      |                |               |               |               |                |        |
|---------------------------------|------------------------|------------------|-----------------|---------------------|------------------|-----------------|----------------------|----------------|---------------|---------------|---------------|----------------|--------|
| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch    | Bin<br>Item     | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure   | Qty on<br>Hand | Qty per Kit   | Total<br>Qty  | Qty<br>Issued | Date<br>Issued | Status |
| ALS4-1032-130                   |                        | Purchased        | No              |                     |                  | 230             | Each                 | 1,214.000      | 1 10 611 (80) | 60<br>U 1     | 10/10         | 124            |        |
|                                 |                        |                  |                 | Location            | <u>)</u>         | Loc             | <u>Oty</u>           | Loc Code       |               |               |               |                |        |
|                                 |                        |                  |                 | PKG11               |                  |                 | 1165                 | 1111           | 911           | <u>۷ لو ک</u> | Ž             |                |        |
|                                 |                        |                  |                 |                     | 114723           |                 | 1165                 |                | _             |               | _             |                |        |
|                                 |                        |                  |                 | ST282               |                  |                 | 10                   |                | _             |               | _             |                |        |
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|                                 |                        |                  |                 | ST381               |                  |                 | 39                   |                | _             |               | _             |                |        |
|                                 |                        |                  |                 |                     | 114654           |                 | 39                   |                | -             |               | _             |                |        |
| AN960JD10L                      | NAS1149D0332J          | Purchased        | No              |                     |                  | 230             | Each                 | 0.0000         | 2             | 2             |               |                |        |
| Washer                          |                        |                  |                 |                     |                  |                 | // <b>/</b>   1   43 | 348            | ,             | 1K5x          | 10/10/        | 21             |        |
| AN960JD416                      | NAS1149D0463J          | Purchased        | <sup>-</sup> No |                     |                  | 230             | Each                 | 24.0000        | 1             | 1             |               |                |        |
|                                 |                        |                  |                 |                     |                  |                 |                      |                |               | H             | loto          | こり             |        |

Location ST300

113288

Loc Code

1115622

Washer

| Dart Aeros | pace Ltd |   |          | ,            |            |          |    |              |     |                               | 1                        |
|------------|----------|---|----------|--------------|------------|----------|----|--------------|-----|-------------------------------|--------------------------|
| W/O:       |          | - |          | V            | VORK ORDEI | RCHANGES |    |              |     |                               |                          |
| DATE ST    | ГЕР      | - | *.       | PROCEDURE CI | HANGE      | *        | Ву | Date         | Qty | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|            |          |   |          | • .•         |            |          |    | ्रह्म        |     | *                             |                          |
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| Part No: _ | Resolu   |   | PAR #: _ |              | itegory:   |          | ·  | No <b>DQ</b> |     | Date: _<br>Date: _            | •                        |

| NCR: |      | W                 | ORK ORDE             | ER NON-CONFORMANC            | E (NCR)        |              |                    |                        |
|------|------|-------------------|----------------------|------------------------------|----------------|--------------|--------------------|------------------------|
|      |      | Description of NC |                      | Corrective Action Section B  |                | Verification | Annroyal           | Annroyo                |
| DATE | STEP | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Section C    | Approval Chief Eng | Approva<br>QC Inspecto |
|      | • .  | •                 |                      |                              |                |              |                    |                        |
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October 5, 2010 11:45:17 AM

Work Order ID: 62618 Parent Item: D206-642-441 Parent Item Name: Replacement Skidtube Required Date: 10/22/10 **Start Date:** 10/05/10 Start Qty: 1.00 Required Qty: 1.00 CCR264SS3-3 170 446.0000 Purchased No Each Cherry Rivet Location Loc Qty Loc Code ST311 446 112314 113539 44 2 8/10/10/20 113973 398 CR3212-4-03 230 Each 1,888.000 Purchased No Cherry Rivet Loc Code Location Loc Qty ST311 1888 111359 112314 2 114436 448 114450 71 BE 10/10/20 114859 1362 D2620 Manufactured No 110 Each 8.0000 Skidtube, 206 Skidtube Loc Oty Location Loc Code LG

| Dart | <b>Aeros</b>                            | pace | Ltd |
|------|---|------|-----|
| _~   | , ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,, | Puv  |     |

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| W/O:        |      |                   | WO                   | RK ORDER CHANG               | SES    |                | .,,,,,, |        |                                     |                          |
| DATE        | STEP | PRO               | CEDURE CHAN          | IGE                          |        | Ву             | Date    | Qty    | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|             |      |                   |                      |                              |        |                |         |        |                                     |                          |
|             |      |                   |                      |                              |        |                |         |        |                                     |                          |
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| Part No     |      | PAR #:            |                      |                              |        |                |         |        |                                     |                          |
|             | Re   | esolution:        | _                    |                              |        |                |         |        | Date: _                             |                          |
| NCR:        | ]    | '                 | WORK ORDE            | R NON-CONFORM                | ANCE   | (NCR)          |         |        | •                                   |                          |
| DATE        | STEP | Description of NC |                      |                              | tion B | 0: 0           |         | cation | Approval                            | Approval                 |
| DAIL        | JILF | Section A         | Initial<br>Chief Eng | Action Description Chief Eng |        | Sign &<br>Date | Secti   | ion C  | Chief Eng                           | QC Inspector             |
|             |      |                   |                      |                              |        |                |         |        |                                     |                          |
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Required Date: 10/22/10

BE 10/10/06

Required Qty: 1.00

October 5, 2010 11:45:17 AM

Work Order ID: 62618 D206-642-441 Parent Item: Parent Item Name: Replacement Skidtube **Start Date: 10/05/10** Start Qty: 1.00 D2646 110 50.0000 Manufactured No Each Aft Cap Location Loc Qty Loc Code FP-4 45 57332 fp5 FP6 52663 D2647 66.0000 Manufactured No 140 Each Cap Location Loc Qty Loc Code FP 66

D2649 Cross Bolt Spacer Manufactured No

66 55352 170 65.0000 Each

23

23

LG

Location Loc Qty Loc Code 65 58545 60652 61496

|         |      |  |                      |                              |          |             |             | •          |                               | ,                        |
|---------|------|--|----------------------|------------------------------|----------|-------------|-------------|------------|-------------------------------|--------------------------|
| W/O:    |      | The second secon | WO                   | RK ORDER CHAN                | GES      | .,.         |             |            |                               |                          |
| DATE    | STEP | PRO  | OCEDURE CHAI         | NGE                          | Ву       | 1           | Date        | Qty        | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|         | :    |  |                      |                              |          |             |             |            | <u>-</u>                      |                          |
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| Part No | :    | PAR #:   | Fault Cate           | jory:                        | NCR: Y   | es N        | o <b>DQ</b> | <b>A</b> : | Date:                         | ·<br>                    |
|         | R    | esolution:   | Disposition          | n:                           | QA: N/C  | Clos        | ed:         |            | Date: _                       |                          |
| NCR:    |      |  | WORK ORDE            | ER NON-CONFORM               | IANCE (N | CR)         |             |            |                               |                          |
| DATE    | CTED | Description of NC  |                      |                              | ection B |             | Verific     | ation      | Approval                      | Approval                 |
| DATE    | STEP | Section A  | Initial<br>Chief Eng | Action Description Chief Eng |          | ın &<br>ate | Section     |            | Chief Eng                     | QC Inspector             |
|         |      |  |                      |                              |          |             |             |            |                               |                          |
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October 5, 2010 11:45:18 AM

Work Order ID: 62618 Parent Item: D206-642-441 Parent Item Name: Replacement Skidtube **Start Date:** 10/05/10 Required Date: 10/22/10 Start Qty: 1.00 Required Qty: 1.00 D2651-1 230 622.0000 22 Manufactured Each 10/10/21 Plug Location Loc Qty Loc Code FP 252 51530 152 61751 100 370 fpa y 8 235 53349 57869 135 D2651-3 230 Each 626.0000 22 Manufactured No 10/20 O-Ring Location Loc Qty Loc Code FP 626 X2Z 130 46114 61962 496 D2654-7 Manufactured No 160 Each 0.0000 Web 13626 D2680-041 Manufactured No 29.0000 

Location ST021

Loc Qty 29 29 55366

Loc Code

Nut Plate

| W/O:    |      |                                | W                    | ORK ORDER CHANGE             | S              |              |                  |                               |                          |
|---------|------|--------------------------------|----------------------|------------------------------|----------------|--------------|------------------|-------------------------------|--------------------------|
| DATE    | STEP | PRO                            | OCEDURE CHA          | NGE                          | Ву             | Date         | Qty              | Approval Chief Eng / Prod Mgr | Approval<br>QC inspector |
|         |      |                                |                      | AMILL.                       |                |              |                  | 1 Tod Wgi                     |                          |
|         |      |                                |                      |                              |                |              |                  |                               |                          |
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| Part No | •    | PAR #:                         | Fault Cate           | egory:                       | NCR: Yes       | No <b>DQ</b> | A:               | Date: _                       |                          |
|         | R    | esolution:                     | Disposition          | on:                          | QA: N/C CI     | osed:        |                  | Date: _                       |                          |
| NCR:    |      | ,                              | WORK ORD             | ER NON-CONFORMAI             | NCE (NCF       | R)           |                  |                               |                          |
|         |      |                                |                      | Corrective Action Section    | - D            |              |                  | Approval                      | 1                        |
| DATE    | STED | Description of NC              | <u> </u>             | ···                          |                |              | cation           |                               | Approval                 |
| DATE    | STEP | Description of NC<br>Section A | Initial<br>Chief Eng | Action Description Chief Eng | Sign & Date    |              | cation<br>tion C | Approval<br>Chief Eng         | Approval<br>QC Inspector |
| DATE    | STEP | Description of NC<br>Section A | 1                    | Action Description           | Sign 8         |              |                  |                               |                          |
| DATE    | STEP | Description of NC Section A    | 1                    | Action Description           | Sign &<br>Date |              |                  |                               |                          |
| DATE    | STEP | Description of NC Section A    | 1                    | Action Description           | Sign 8         |              |                  |                               |                          |
| DATE    | STEP | Description of NC Section A    | 1                    | Action Description           | Sign &<br>Date |              |                  |                               |                          |
| DATE    | STEP | Description of NC Section A    | 1                    | Action Description           | Sign &<br>Date |              |                  |                               |                          |
| DATE    | STEP | Description of NC Section A    | 1                    | Action Description           | Sign &<br>Date |              |                  |                               |                          |
| DATE    | STEP | Description of NC Section A    | 1                    | Action Description           | Sign &<br>Date |              |                  |                               |                          |
| DATE    | STEP | Description of NC Section A    | 1                    | Action Description           | Sign &<br>Date |              |                  |                               |                          |

October 5, 2010 11:45:18 AM

Work Order ID: 62618 Parent Item: D206-642-441 Parent Item Name: Replacement Skidtube Required Date: 10/22/10 Start Date: 10/05/10 Start Qty: 1.00 Required Qty: 1.00 D3535-15 No 230 6.0000 Manufactured Each Wearshoe Location Loc Qty Loc Code FP18 6 61241 6 D3535-23 230 19.0000 Manufactured No Each Wearshoe Location Loc Qty Loc Code FP 61830 7 FP021 20 60231 11 D3535-37 Manufactured 230 9.0000 Each 10/10/24 Wearshoe Location Loc Qty Loc Code FP 9 56101 D3536-15 230 10.0000 Manufactured No Each Location 56055 60875 FP11 59238

|           | -    |                   |  |                              |                      |                 |                               |                          |
|-----------|------|-------------------|--|------------------------------|----------------------|-----------------|-------------------------------|--------------------------|
| W/O:      |      |                   | W  | ORK ORDER CHANG              | ES                   |                 |                               |                          |
| DATE STEP |      | PROCEDURE CHANGE  |  |                              | Ву                   | Date Qty        | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|           |      |                   |  |                              |                      |                 |                               |                          |
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| Part No   | :    | PAR #:            | Fault Cate   | egory:                       | _ <b>NCR</b> : Yes I | No <b>DQA</b> : | Date: _                       |                          |
|           |      | solution:         | Disposition:   |                              |                      | sed:            | Date:                         |                          |
| NCR:      |      |                   | WORK ORE   | DER NON-CONFORMA             | NCE (NCR             | )               |                               |                          |
| DATE      | STEP | Description of NC | Corrective Action Section B                          |                              |                      | Verification    | Approval                      | Approval                 |
| DATE      |      | Section A         | Initial<br>Chief Eng                                 | Action Description Chief Eng | Sign &<br>Date       | Section C       | Chief Eng                     | QC Inspector             |
|           |      |                   |  |                              |                      |                 |                               |                          |
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October 5, 2010 11:45:19 AM

Work Order ID: 62618 D206-642-441 Parent Item: Parent Item Name: Replacement Skidtube **Start Date:** 10/05/10 Required Date: 10/22/10 Start Qty: 1.00 Required Qty: 1.00 D3536-23 230 8.0000 Manufactured Each Gasket Location Loc Qty Loc Code FP011 61237 D3536-37 Manufactured 230 Each 8.0000 No 15/01/01 Gasket Location Loc Qty Loc Code FP 56102 D3537-1 230 Each 14.0000 Manufactured No H 10110121 Wearpad Location Loc Qty Loc Code FP 55465 FP17 13 B61986 57713 60491 61640 D3537-3 230 Each 8.0000 Manufactured No Wearpad Loc Oty Location Loc Code FP17 .60866

|           |           |                   |  |                 |                |                      |                                     | -                        |  |
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| W/O:      |           |                   | W  | ORK ORDER CHANG | ES             |                      |                                     | 1                        |  |
| DATE STEP |           | PROCEDURE CHANGE  |  |                 | Ву             | Date Qty             | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
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| Part No   | <b>:</b>  | PAR #:            | Fault Cate                                     | egory:          | _ NCR: Yes I   | No DQA:              | Date: _                             |                          |  |
| Resc      |           | esolution:        | Disposition                                    | on:             | _ QA: N/C Clo  | A: N/C Closed: Date: |                                     |                          |  |
| NCR:      |           |                   | WORK ORD                                       | ER NON-CONFORMA | NCE (NCR)      |                      |                                     |                          |  |
| DATE      | STEP      | Description of NC | Corrective Action Section B                    |                 |                | Verification         | Approval                            | Approval                 |  |
| DAIL      | Section A |                   | Initial Action Description Chief Eng Chief Eng |                 | Sign &<br>Date | Section C            |                                     | QC Inspector             |  |
|           |           |                   |  |                 |                |                      |                                     |                          |  |
|           |           |                   | <u>.</u>                                       |                 |                |                      |                                     |                          |  |
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October 5, 2010 11:45:19 AM

Work Order ID: 62618 D206-642-441 Parent Item: Parent Item Name: Replacement Skidtube Required Date: 10/22/10 Start Date: 10/05/10 Start Qty: 1.00 Required Qty: 1.00 MS27039-1-08 Purchased No 230 Each 1,585.000 Screw **Location** Loc Qty Loc Code ST291 1585 110835 473 114718 112 115108 1000 MS27039-4-06 230 Each 108.0000 Purchased No 10/10/24 Screw Location Loc Qty Loc Code ST292 108 109061 14 115460 94 MS27039C1-08 Purchased No 230 Each 1,077.000 60 10/10/24 **SCREW** Location Loc Qty Loc Code FP 276 115336 276 ST293 801 y60 115589 800 19185

| W/O:        |           |                   | W                         | ORK ORDER CHANG              | SES       |              |          |                               |                          |
|-------------|-----------|-------------------|---------------------------|------------------------------|-----------|--------------|----------|-------------------------------|--------------------------|
| DATE        | STEP      | PR                | PROCEDURE CHANGE          |                              |           | Date         | Qty      | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|             |           |                   |                           |                              |           |              |          | -                             |                          |
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| Part No     | ·         | PAR #:            | Fault Cate                | gory:                        | NCR: Yes  | No <b>DQ</b> | A:       | _ Date: _                     |                          |
| Resolution: |           | olution:          | Dispositio                | QA: N/C Closed:              |           |              | Date:    |                               |                          |
| NCR:        |           |                   | WORK ORD                  | ER NON-CONFORM               | ANCE (NCF | 1)           |          |                               |                          |
| DATE        | STEP      | Description of NC | Corrective Action Section |                              |           | Verifi       | fication | Approval                      | Approval                 |
| DAIL        | Section A |                   | Initial<br>Chief Eng      | Action Description Chief Eng |           |              | ion C    | Chief Eng                     | QC Inspector             |
|             |           |                   |                           |                              |           |              |          |                               |                          |
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# **Picklist Print**

October 5, 2010 11:45:20 AM

Page 8

Work Order ID: 62618

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Washer

Purchased

No

230

5,239.000 Each

10/10/24

| Location | Loc Qty | Loc Code |                                       |
|----------|---------|----------|---------------------------------------|
| ST297    | 5239    |          |                                       |
| 113524   | 10      |          |                                       |
| 113737   | 150     |          |                                       |
| 115000   | 125     |          |                                       |
| 115698   | 78      |          | · · · · · · · · · · · · · · · · · · · |
| 115816   | 1276    |          | <u> 760</u>                           |
| 115832   | 3600    |          |                                       |

| W/O:    |      |                               | V                    | ORK ORDER CHANGI             | ES             |              |          | ·                                   |                          |
|---------|------|-------------------------------|----------------------|------------------------------|----------------|--------------|----------|-------------------------------------|--------------------------|
| DATE    | STEP | PROC                          | EDURE CHANGE         |                              | Ву             | Date         | Qty      | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|         |      |                               |                      |                              |                |              |          | Prod Mgr                            |                          |
|         |      |                               |                      |                              |                |              |          |                                     |                          |
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| Part No | •    | PAR #:                        | _ Fault Ca           | tegory:                      | NCR: Yes       | No <b>DQ</b> | A:       | Date: _                             |                          |
|         |      | esolution:                    |                      |                              |                |              | Date:    |                                     |                          |
| NCR:    |      | W                             | ORK OR               | DER NON-CONFORMA             | NCE (NCR       | )            |          |                                     |                          |
| DATE    | STEP | P Description of NC Section A |                      | on B                         | Verification   |              | Approval | Approval                            |                          |
| DATE    |      |                               | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date |              | ion C    | Chief Eng                           | QC Inspector             |
|         |      |                               |                      |                              |                |              |          |                                     | ,                        |
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|         |      |                               |                      |                              | 1              |              |          |                                     |                          |

QTY QTY QTY QTY PART NUMBER DESCRIPTION Х D2650-1 SKIDTUBE ASSEMBLY D2650-3 SKIDTUBE ASSEMBLY Х X D2650-5 SKIDTUBE ASSEMBLY D2650-7 SKIDTUBE ASSEMBLY х D2600-1-160 EXTRUSION 1 1 D2654-1 WEB D2654-3 WEB D2654-5 WEB D2654-7 WEB D2646 AFT CAP D2647 CAP 1 1 1 17 18 19 23 D2649 CROSS BOLT SPACER 16 18 14 22 D2651-1 PLUG 16 18 14 22 D2651-3 O-RING 1 1 D2680-041 NUT PLATE 2 2 D3286-1 DOUBLER 2 2 D3286-3 STUD 42 44 54 ALS7-1032-130 INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) 2 2 AN960JD10L WASHER 2 2 CCR264SS3-3 RIVET 2 2 2 2 2 2 2 2 CR3212-4-03 RIVET 2 2 2 2 MS27039-1-08 SCREW 1 1 MS27039-4-06 SCREW 1 1 1 1 AN960JD416 WASHER 52 52 CR3212-4-04 RIVET

SIL NO. 42418 pf10-10-53

D

В

NOTES:

2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4,4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) WELD PER DART QSI 004

8

D

9) DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND, IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE, A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015

11) INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.

13) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED

| DESIGN |                          | DS   | DART AFROSPAC | FUS      | A INC |
|--------|--------------------------|--|---------------|----------|-------|
| REV.   |                          |  | DESCRIPTION   | BY)      | DATE  |
| Α      | NEW I                    | SSUE   | DS            | 97.03.25 |       |
| В      | AS MA                    | NUFACTURE  | DS            | 97.06.26 |       |
| С      | CHANG                    | GE HOLE PAT  | DS            | 97.10.29 |       |
| D      |                          | AW; INCORP.<br>SROUND HAN  | СР            | 04.05.17 |       |
| E      | RMOV                     | E CBORE, CH  | CP            | 06.03.30 |       |
| F      | 6 ADDE<br>TRANS<br>UPDAT | NG UPDATED  OUT OF THE PROPERTY OF THE PROPERT | AJS           | 08.08.08 |       |

| DRAWN      | AµS  | PORT HADLOCK, WA  |                     |  |  |  |  |
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| CHECKED    | 1    | DRAWING NO.   | REV. F              |  |  |  |  |
| MFG. APPR. | 1    | D2650 SH  | EET 1 OF 6          |  |  |  |  |
| APPROVED   | 10   | TITLE   | SCALE               |  |  |  |  |
| DE APPR.   |      | 206/407 SKIDTUBE ASSEMBLIES   | NTS                 |  |  |  |  |
| DATE 08.0  | 80.8 | COPYRIGHT © 1997 BY DART AEROSPACE USA THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS O HOT TO BE USED FOR MY PURPOSE OR COME DO COMMUNICATED TO ANY OTHER WITTEN PERSASSON FROM DATA PARESPACE USA. INC. | ONDITION THAT IT IS |  |  |  |  |

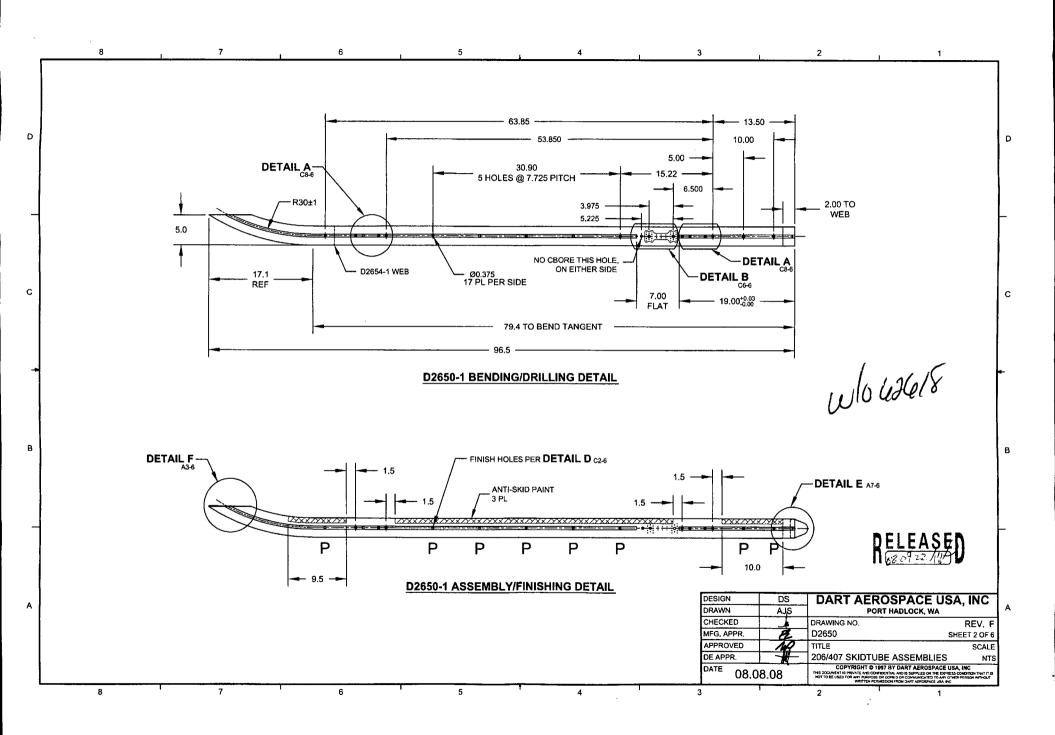
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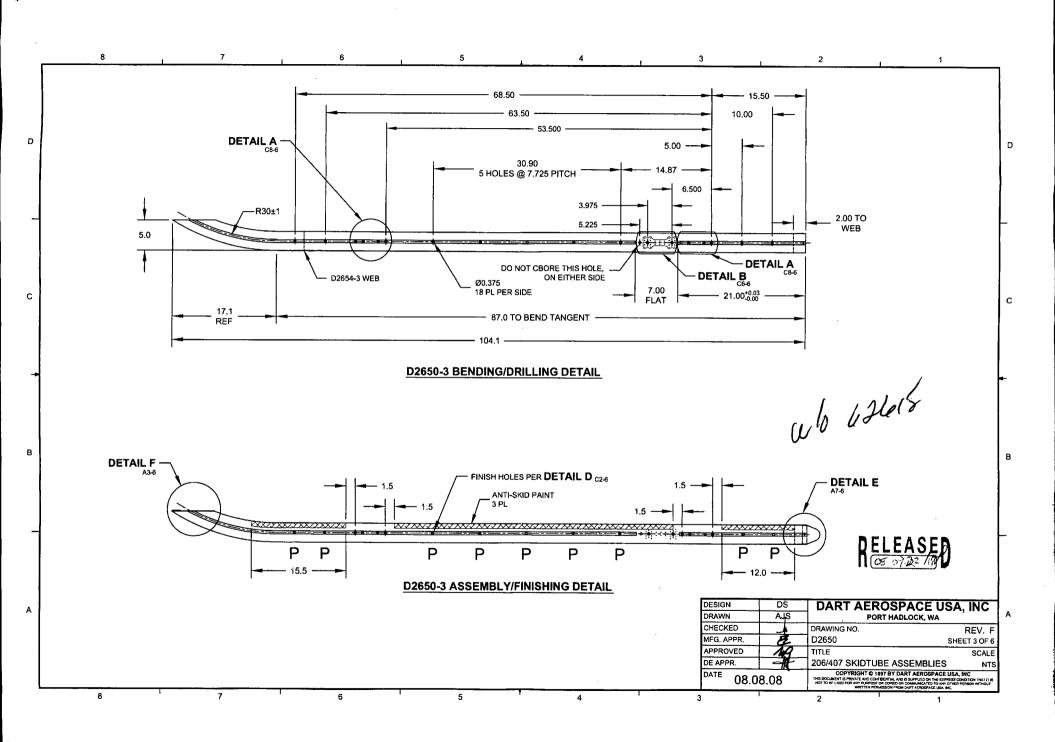
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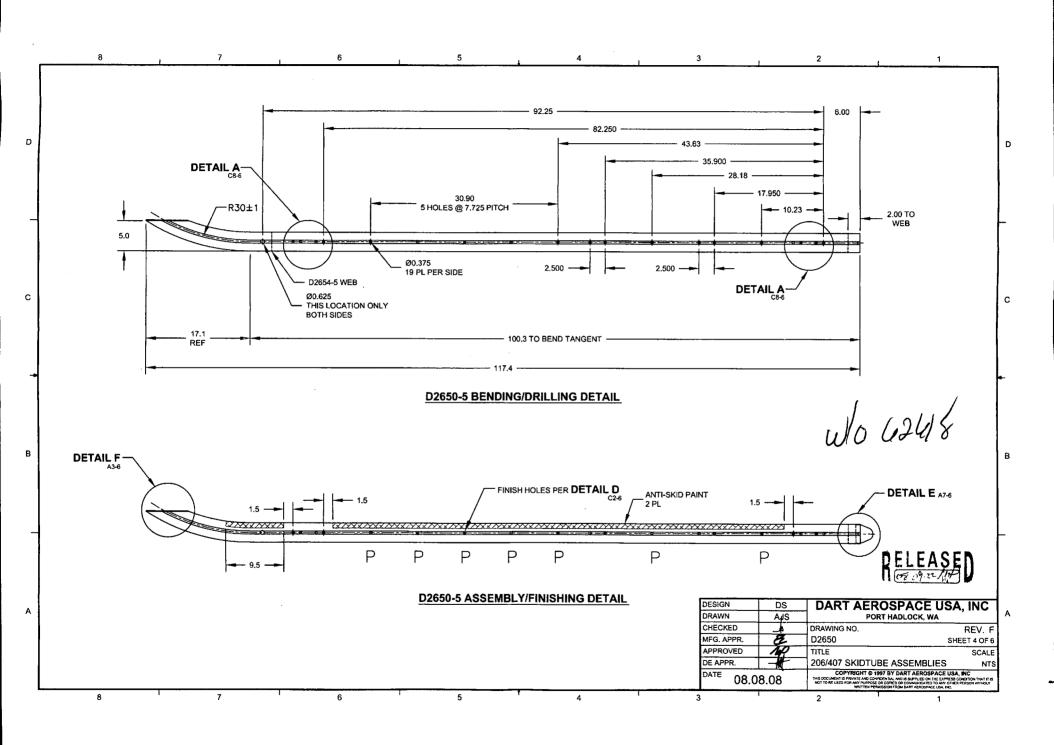
| DATE     STEP     PROCEDURE CHANGE     By     Date     Qty     Approval Chief Eng / Prod Mgr     Approval Chief Eng / Prod Mgr   |         |
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| Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:   |         |
| Resolution: Disposition: QA: N/C Closed: Date:   |         |
| NCR: WORK ORDER NON-CONFORMANCE (NCR)  |         |
| DATE STEP Description of NC Corrective Action Section B Verification Approval Approval Approval Approval   | roval   |
| Section A Section A Section A Section Chief Eng Chief En | spector |
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| W/O:        |      | WORK ORDER CHANGES |                      |                              |                |              |   |                          |  |  |  |  |
|-------------|------|--------------------|----------------------|------------------------------|----------------|--------------|---|--------------------------|--|--|--|--|
| DATE        | STEP | PRO                | CEDURE CH            | ANGE                         | Ву             | Date Q       | Approval Chief Eng / Prod Mgr   | Approval<br>QC Inspector |  |  |  |  |
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| Part No:    |      | PAR #:             | Fault Cat            | egory:                       | _ NCR: Yes     | No DQA: _    | Date: _   |                          |  |  |  |  |
| Resolution: |      |                    | Disposition: Q       |                              |                | osed:        | Date: _   | _ Date:                  |  |  |  |  |
| NCR:        |      | V                  | VORK ORE             | DER NON-CONFORMA             | ANCE (NCF      | R)           | t to the total total to the total total to the total total to the total total total to the total |                          |  |  |  |  |
| DATE        | STEP | Description of NC  |                      | Corrective Action Section    |                | Verification | n Approval  | Approval                 |  |  |  |  |
| DAIL        | SILF | Section A          | Initial<br>Chief Eng | Action Description Chief Eng | Sign 8<br>Date | K Section C  |   | QC Inspector             |  |  |  |  |
|             |      |                    |                      |                              |                |              |   |                          |  |  |  |  |
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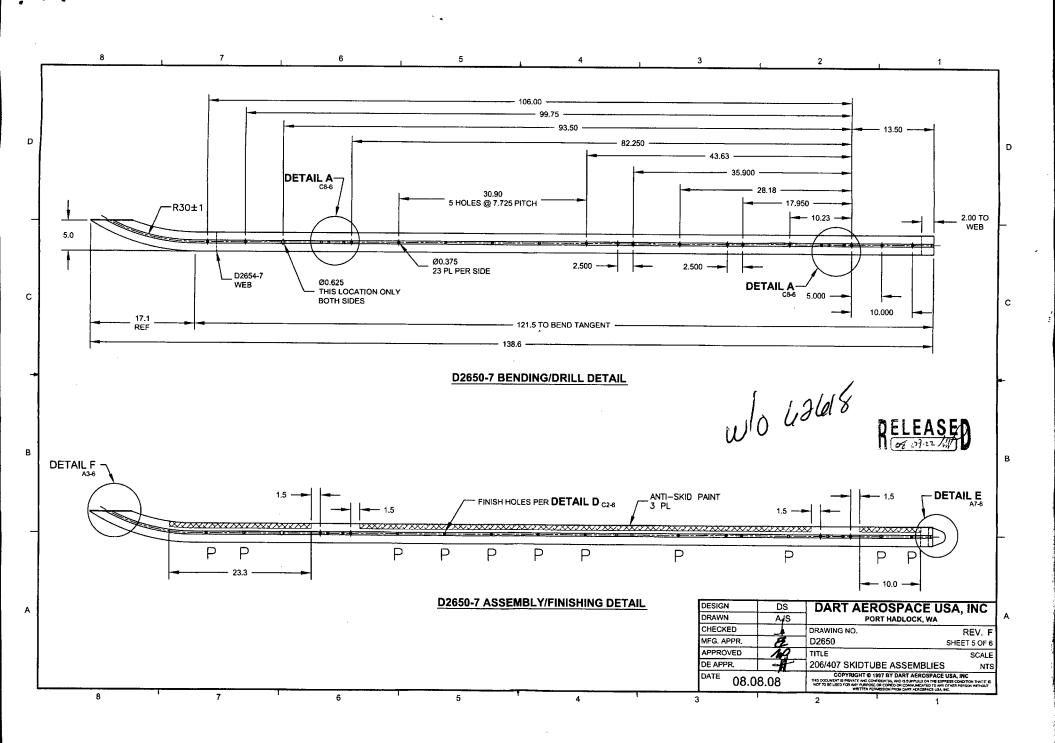


| W/O:        |      |  | W                                       | ORK ORDER CHANG              | ES          |              |          |                                     |                          |
|-------------|------|--|---|------------------------------|-------------|--------------|----------|-------------------------------------|--------------------------|
| DATE        | STEP | PRO                                      | OCEDURE CHA                             | NGE                          | Ву          | Date         | Qty      | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
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| Part No     | •    | PAR #:                                   | Fault Cate                              | gory:                        | NCR: Yes    | No DO        | QA:      | Date: _                             |                          |
| Resolution: |      |  | Dispositio                              | _ QA: N/C (                  |             |              |          |                                     |                          |
| NCR:        |      | 1  | WORK ORD                                | ER NON-CONFORM               | ANCE (NC    | R)           |          |                                     |                          |
|             |      | Description of NC                        |   | tion B                       | Veri        | Verification | Approval | Approval                            |                          |
| DATE        | STEP | Section A                                | Initial<br>Chief Eng                    | Action Description Chief Eng | Sign<br>Dat | & Se         | ction C  | Chief Eng                           | QC Inspector             |
|             |      |  |   |                              |             |              |          |                                     |                          |
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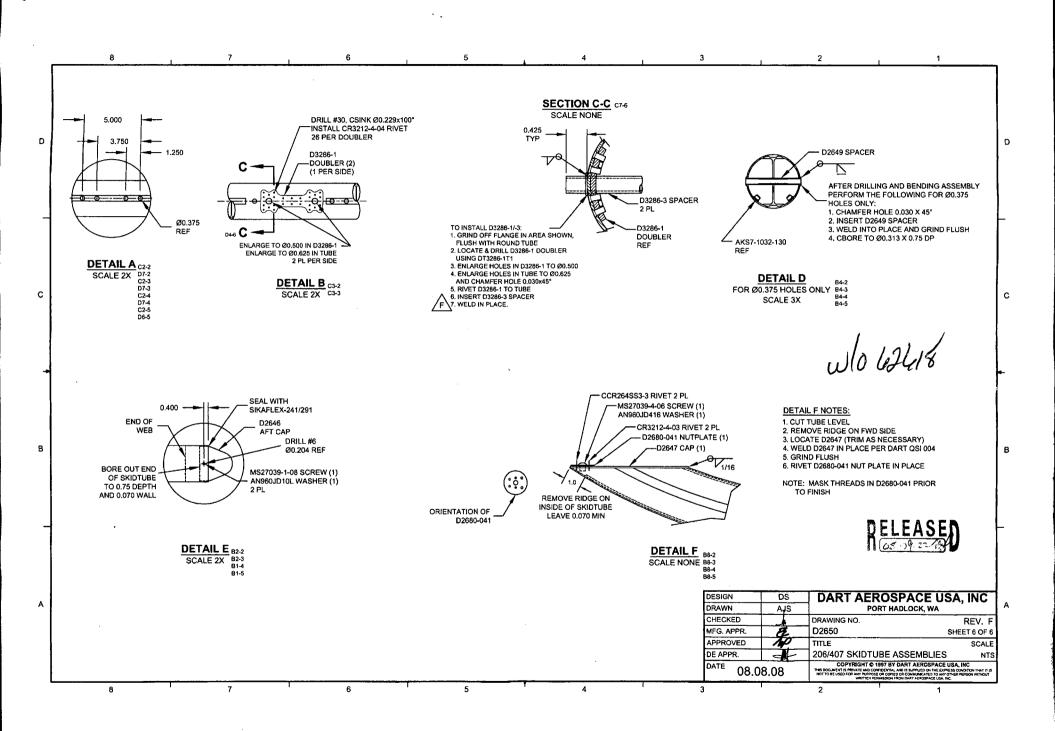
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| W/O:            |      |                   | WORK ORDER CHANGES   |                              |                |                        |           |                               |                          |  |  |  |
| DATE            | STEP | PRO               | OCEDURE CHA          | NGE                          | Ву             | Date                   | Qty       | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |  |  |
|                 |      |                   |                      |                              |                |                        |           |                               |                          |  |  |  |
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| Part No: PAR #: |      | PAR #:            | Fault Category: NC   |                              |                | NCR: Yes No DQA: Date: |           |                               |                          |  |  |  |
| Resolution:     |      |                   | Dispositio           | _ QA: N/C CI                 |                |                        |           |                               |                          |  |  |  |
| NCR:            |      |                   | WORK ORD             | ER NON-CONFORMA              | NCE (NCR       | 3)                     |           |                               |                          |  |  |  |
| DATE            | STEP | Description of NC |                      | on B                         | Verifi         | cation                 | Approval  | Approval                      |                          |  |  |  |
| DAIL            | SIEF | Section A         | initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date |                        | ion C     | Chief Eng                     | QC Inspector             |  |  |  |
|                 |      |                   |                      |                              |                |                        |           |                               | -                        |  |  |  |
| i               |      |                   |                      |                              | ŀ              |                        |           |                               |                          |  |  |  |
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| W/O:        |        |                   | WORK ORDER CHANGES                           |                              |                |         |       |                                     |                          |  |
| DATE        | STEP   | PRO               | PROCEDURE CHANGE                             |                              |                |         |       | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|             | <br>   |                   |  |                              |                |         |       |                                     |                          |  |
|             |        |                   |  |                              |                |         |       |                                     |                          |  |
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|             |        |                   |  |                              |                |         |       |                                     |                          |  |
| Part No     | :      | PAR #:            | Fault Cate                                   | gory:                        | NCR: Yes       | No DQA  | \:    | Date:                               |                          |  |
| Resolution: |        | Dispositio        |  |                              |                | Date:   |       |                                     |                          |  |
| NCR:        |        | V                 | VORK ORD                                     | ER NON-CONFORMAN             | NCE (NCR       | )       |       |                                     | 7,00                     |  |
| DATE        | STEP   | Description of NC | ļ  | Corrective Action Section    |                | Verific | ation | Approval<br>Chief Eng               | Approval                 |  |
| - DAIL      | SIEP   | Section A         | Initial<br>Chief Eng                         | Action Description Chief Eng | Sign &<br>Date | Section | on C  |                                     | QC Inspector             |  |
|             |        |                   |  |                              |                |         |       |                                     |                          |  |
|             |        |                   |  |                              | l.             |         |       |                                     |                          |  |
|             |        |                   |  |                              |                |         |       |                                     |                          |  |
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| Dart Aeı    | ospace | e Ltd                          |                      |  |           |                       |                    |           |                               | Apr. w                   |
|-------------|--------|--------------------------------|----------------------|--|-----------|-----------------------|--------------------|-----------|-------------------------------|--------------------------|
| W/O:        |        |                                | W                    | ORK ORDER CHAI                                   | NGES      |                       |                    |           |                               |                          |
| DATE        | STEP   | PRO                            | CEDURE CH            | ANGE   |           | Ву                    | Date               | Qty       | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|             |        |                                | *                    |  |           |                       |                    |           |                               |                          |
| ¥ 7         |        |                                |                      |  |           |                       |                    |           |                               |                          |
|             |        |                                |                      |  |           |                       |                    |           |                               |                          |
|             |        |                                |                      |  |           |                       |                    |           |                               |                          |
| Part No     | •      | PAR #:                         | Fault Cat            | egory:   | NCF       | R: Yes N              | lo <b>DQ</b>       | <b>A:</b> | Date:                         | Į.                       |
| Resolution: |        |                                | Disposition: C       |  |           | QA: N/C Closed: Date: |                    |           |                               |                          |
| NCR:        |        | V                              | VORK ORD             | DER NON-CONFOR                                   | MANCE     | (NCR)                 |                    |           |                               |                          |
| DATE        | STEP   | Description of NC<br>Section A | Initial<br>Chief Eng | Corrective Action  Action Description  Chief Eng | Section B | Sign &<br>Date        | Verific<br>Section |           | Approval<br>Chief Eng         | Approval<br>QC Inspector |
|             | :      |                                |                      | 0.10. 2.19                                       | :         |                       |                    |           | · .                           |                          |
|             |        |                                |                      |  |           |                       |                    |           |                               |                          |
| ·           |        |                                |                      |  |           |                       |                    |           |                               | ·                        |
|             |        |                                |                      |  |           |                       |                    |           |                               |                          |

NOTE: Date & initial all entries

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